Work Order ID 108287 *108287* October-11-13 9:45:50 AM Page 1 D4095-043 Item ID: Accept *N900040100* Revision 1D: Setup Start Item Name: Wearplate Assembly Stop Start Date: 10/11/13 Start Qty: 12.00 Cust Item ID: Required Date: 10/25/13 Req'd Qty: 12.00 Customer: Reference: Process Plan: Approvals: Date: Run Tooling: Start Date: QC: Date: SPC (Y/N): Stop Date: Sequence 1D/ Operation Set Up/ Tool ID Work Center 1D Tool # Plan Description Accept Reject Run Hours Reject Insp. Code Draw Nbr Revision Nbr Qty Qty Number Stamp B D4095 100 0.00 FLOW WATER JET *100* Waterjet EL 13-10-14 Memo 0.00 FLOW CNC Waterjet I-Cut as per Dwg (D4095-3) Dug Rev. 3 Prog Rev: 3 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 12 & 13-10-14 Memo 0.00 Quality Control DAS 120 QC8- Inspect parts - second check *120* 0.00 BIG 15 QC' Memo Quality Control

No

DQA:	Date:		-
QA Closed:	Date:		
DEPARTMENT/PROC	CESS		
Wa	ter Jet	Engineering	
Prod. Eng	. Coor.	Quality	
Rec/Store/Pac	kaging	Other	

Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root						ption of work order update	170	nitial		ction	Sign &		
Cause	-	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						The second second							
Equip/Tooling							10						
Operator										=			
Material	_		1					100		3			
Setup	_						1					ISS LAN	
Other	_										in the		
Process													
Supplier Training										-			
Unapproved							-			1.4			
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		Bending				Bend		Grain		1.3	Ovalized		Pressure/Forced
	(I)	Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	, Ind	Part Incorrec	ct	Weld
10		Crushed/	Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	1	Part Moved		
	7	Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong	
F A		Inspection	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
allio A		Ripples in	Bend			Drill Holes		Offset				Mary Strate	
(GI	ğ	Torque W	aves in E	xtrusio	n	Drawing		Out of (Calibration				
da i		Turning S	equence			Finish		CONTRACTOR OF THE PARTY OF THE	equence				排工管动作等。
	Wave/Twist in Tube Folio			Outside Dimensions									

October-11-13 9:45:50 AM

Page 2

Item ID:

D4095-043

Accept

N900040100

Setup Start

Revision ID: Item Name:

Wearplate Assembly

Start Date: 10/11/13 Required Date: 10/25/13

Start Qty: 12.00 Req'd Qty: 12.00 *12*

Cust Item 1D: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID 130

130

Operation Description

Set Up/ Run Hours

Tool # Plan

Code

Accept Qty

Reject Reject Qty

Insp.

Brake NO

NC BRAKE

0.00

0.00

1.1

Number Stamp

Brake NC

1- bend section C-C first

2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155

3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

DAS 27

Quality Control

Memo

Memo

0.00

Ensure joggle as per dwg D4095

150

150 Large Fab

Large Fab

Weld per dwg A/R Hardcoat S.S. Batch MJ7/12 0.00

Large Fab

Memo

0.00

JBC 13-11-06

NCR:	Yes /	No
IVCII.	163 /	110

DQA:	Date:		100
U.S. San		ATTEN VEX	

	QA Closed: Date:												
Work Orde	r:					DISPOSITION			d.	AGAINST DE	PARTMENT	/PROCESS	
Part No						Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Pro Rec/Stor	Engineering Quality Other	
Root	Post Descrip				ption of work order update	of work order update Initial Action							
Cause	3	Date	Step	Qty		or Non-conformance	1000	f Eng		ription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training	31	Dute	Step	diy									
Unapproved													
						F/	AULT	CATE	GORY			P P S N	
Landin	ng G	ear			_	General					i de la companya de		
4	_	Bending				Bend		Grain			Ovalized		Pressure/Forced
	$\overline{}$	Centre No	t Concer	ntric to (0/5	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure
27.		Cracks				Broken/Damaged	-	-	on Incomplete		Part Incorre		Weld
	_	Crushed/0	Crimped		-	Burrs	-		ions Incomplete/	Unclear	Part Lost/M	Issing	Wrong Stock Pulled
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No. of	_	Heat Trea		+ 167	-	Countersink		Mislabe			Positioned V	THE REAL PROPERTY AND ADDRESS OF THE PERTY	Other
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H.	_	Ripples in				Drill Holes		Offset	and the section of		- + 100 E		NAME OF THE PARTY
	$\overline{}$	Torque W			n	Drawing	\vdash		Calibration		12		
0	-	Turning S			-	Finish	\vdash		Sequence		(1) (1) (1) (1) (1) (1) (1) (1) (1) (1)		
SECTION 1	2	Wave/Tw	ist in Tub	e		Folio		Outside Dimensions					

108287

Page 3

Item ID:

D4095-043

Accept

N900040100

Setup Start

Revision ID: Item Name:

Wearplate Assembly

Start Date: 10/11/13 Start Qty: 12.00 Req'd Qty: 12.00

12 *12*

Cust Item ID: Customer:

Required Date: 10/25/13

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

150

Operation Description

Set Up/ Run Hours 0.00

Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

160

Quality Control

Memo

Memo

Memo

QC10- Inspect visual per QSI004- ground welds

27 9-89

170

170 QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS 27

180

180 HandFmish

Hand Finishing

0.00

0.00

COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER

A/R ROCKGUARD BATCH: 127155

11

13-11-06

BICD.	Vac	/ 100	
NCR:	Yes	/ No	

DQA:	Date		
No. of the last of		PER PROPERTY OF THE PARTY OF TH	21 21-22-31

					4					QA Closed:	Date:		
Work Order	*				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			0 7017 232	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	- 1	nitial	A	ction	Sign &		All Park	
Cause	Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector	
oc/Data quip/Tooling Operator Waterial Setup Other Process Supplier Training Unapproved						ALI	T CATE	CORV					
100000			-		General	HUL	CATE	GUNT					
	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Over/Under tolerance Tempe Part Incorrect Weld Part Lost/Missing Wrong Part Moved Positioned Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Ripples in		1 6 6		Drill Holes		Offset		- 1				
	Torque V		xtrusion	1	Drawing			Calibration	Lat Cu	15	Y DECEMBER	N.E. A. C.	
	Turning S				Finish		Out of Sequence			Marie Maria Maria			

Outside Dimensions

Wave/Twist in Tube

Required Date: 10/25/13

108287

Page 4

Item ID:

D4095-043

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Wearplate Assembly

10/11/13

Start Qty: 12.00 Reg'd Qty: 12.00

12 *12*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

190

190

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

11

Reject Qty

Reject Insp. Number Stamp

200

200

Packaging Packaging

Identify as per dwg & Stock Location: FP-007

Memo

0.00

11 L & Al 13/a/07

210

210

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

NCR:	Vac	/ No	
INCIA.	103	/ INU	

DQA:	Date:		
14 8 8 1		HALLEN S. P. C.	x 134 [11]

										QA Closed:	Date	2:	1-2-53
Work Order					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
					Rework				Crosstube		Water Jet	Enginee	The control of the co
Part No.					Scrap			Machining	Small Fab	1.50 A 1.	d. Eng. Coor.	- ROH HE	ality
					Use-as-is]]]		noforming	Finishing	Rec/Sto	re/Packaging	0	ther
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	Cracks				Broken/Damaged	In	specti	ion Incomplete		Part Incorre	ct	Weld	
	Crushed/	Crimped			Burrs	In	struct	ions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Sto	ick Pulled
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	Inspectio	n Strip in	Tube		Cut Too Short	M	lisread	1	19	Power Lass/	Surge	Other	1 = /6
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	Torque W	aves in E	Extrusion	1	Drawing	0	ut of (Calibration			TE STREET		
20.	Turning S	equence			Finish		ut of s	Seguence		20 100			

Outside Dimensions

Wave/Twist in Tube

Picklist Print

October-11-13 9:45:54 AM

Work Order ID: 108287

Parent Item:

D4095-043

Parent Item Name: Wearplate Assembly

108287

D4095-043

Start Date: 10/11/13

Start Qty: 12.00

Required Date: 10/25/13

Required Qty: 12.00

Comments:

MB04516GA

IPP Rev:A nerw issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Purchased

Bin Primary Item Location

No

Last Location Route Seq ID

100

Qty on Measure Hand SI

Qty per Kit Total 510.3940

Qty 2.275 29

Issued

Qty

Issued

Date Status

304/316 Sheet .063

Unit of

**

EL 13-10-14

Location Loc Qtv Loc Code MAT020 510,3939998 123136 140.2 M126159 31.5 M126915 338,694 74.31 Page 1

		#1 marco
NCR:	Yes	/ No

DQA:	Date:		
	3	CHEREL	202

	on 1. nea					F./ 5				QA Closed:	Date:	
Work Order: DISPOSITION							-		AGAINST D	EPARTMENT/	PROCESS	
Part N NCR N	0				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- III 1670000	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ir	nitial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Des	cription	Date	Verification	QC Inspector
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Later 1	Inspectio		Tube		Cut Too Short		Misread			Power Loss/S		Other
	Ripples in	250000	Tube		Drill Holes		Offset		12		_	
	Torque V		Extrusion	1	Drawing			Calibration		1350	Det de la constante de la cons	
	Turning S			*	Finish			Sequence				

Outside Dimensions

Wave/Twist in Tube

DART AEROSPACE LTD	Work Order:	108787
Description: Wearplate		1
- Partition Plate	Part Number:	D4095-3
Inspection Dwg: D4095 Rev: B		
Nev. B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	\$ 0.170	٠,٠			
0.300	+/-0.010	304		- 6	- Shime;	
0.300	+/-0.010	.303	1			
2.432	+/-0.010	2.44	-			
3.227	+/-0.010	3.221	~			
4.06	+/-0.030	4.05				
2.50	+/-0.030	7 5				
4.98	+/-0.030	4.984	-			
8.43	+/-0.030	8.432				
11.50	+/-0.030	5.735			- 0	
21.750	+/-0.010	717			TRMCK	
3.500	+/-0.010	3 /	-			
12.22	+/-0.030	12.37				
6.000	+/-0.010	6				
12.100	+/-0.010					
21.00	+/-0.030	21				
30.000	+/-0.010	2				
36.000	+/-0.010	36				
38.88	+/-0.030	38.875				
0.063	+/-0.010	0.06	-			
		0.08			TKMET	
9						

Measured by: El Audited by: 9-89 Preliminary Approval:

Date: 13-10-14

Date: 5 10 5

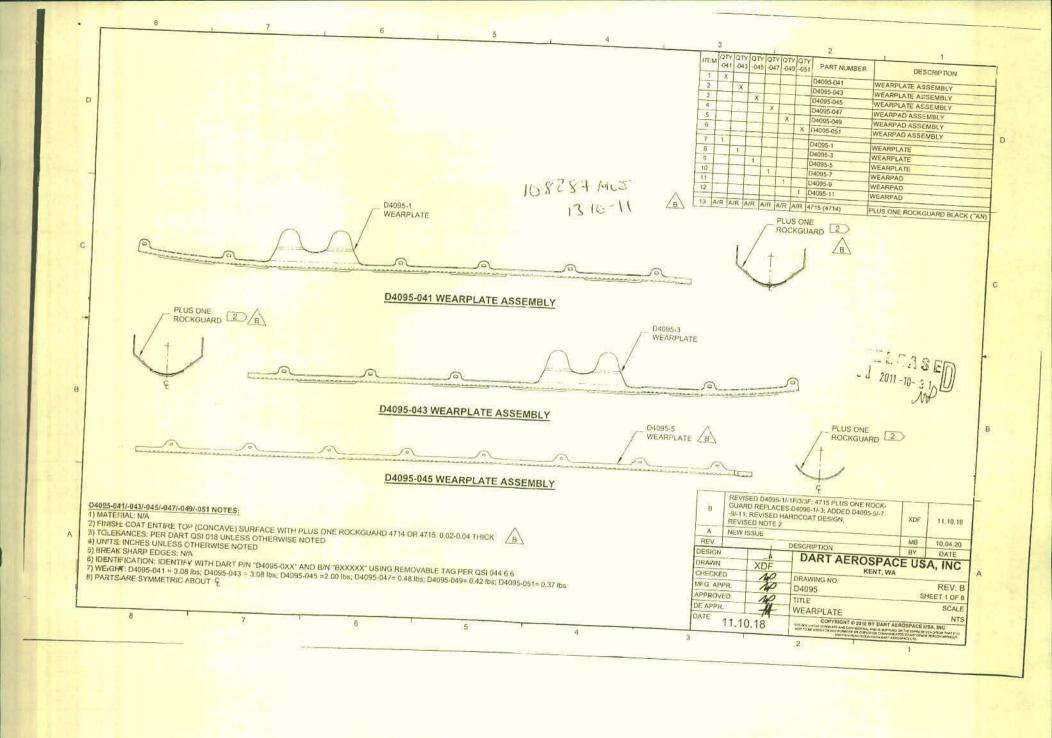
Date: Date:

Kev	Date	Change		
A	11.02.18	New Issue DIO Dices	Revised by Approve	ed
B	11.11.08	Dimensions updated per Dwg Rev B	KJ IN	
			KJ W	

NCR:	Yes /	No
14011.	103/	140

DQA:	Date:	4
10-10		BIT IS

QA Closed: Date:													
Work Order	r					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part N	0		Rework Scrap Use-as-is Work Order Update						Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet rod. Eng. Coor. tore/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	- 1	nitial	Ad	ction	Sign &		101111
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						57				- 3			
Equip/Tooling								1					
Operator													
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Landin						General Bend		Grain		63	Ovalized	T. C.	Pressure/Forced
· · · · · · · · · · · · · · · · · · ·	_	Bending Centre No	t Concor	atric to	0/5	BOM/Route	H	Hardwa		1.2	September 200	der tolerance	Temperature/Cure
	_	Cracks	it concer	ILITE TO	U/3 -	Broken/Damaged	H	LEGIE I			Part Inco	_	Weld
100		Crushed/C	rimned		-	Burrs	-	Inspection Incomplete Instructions Incomplete/Unclear		Part Lost,		Wrong Stock Pulled	
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	설	Wave/Twi	ist in Tub	oe		Folio		Outside	Dimensions				



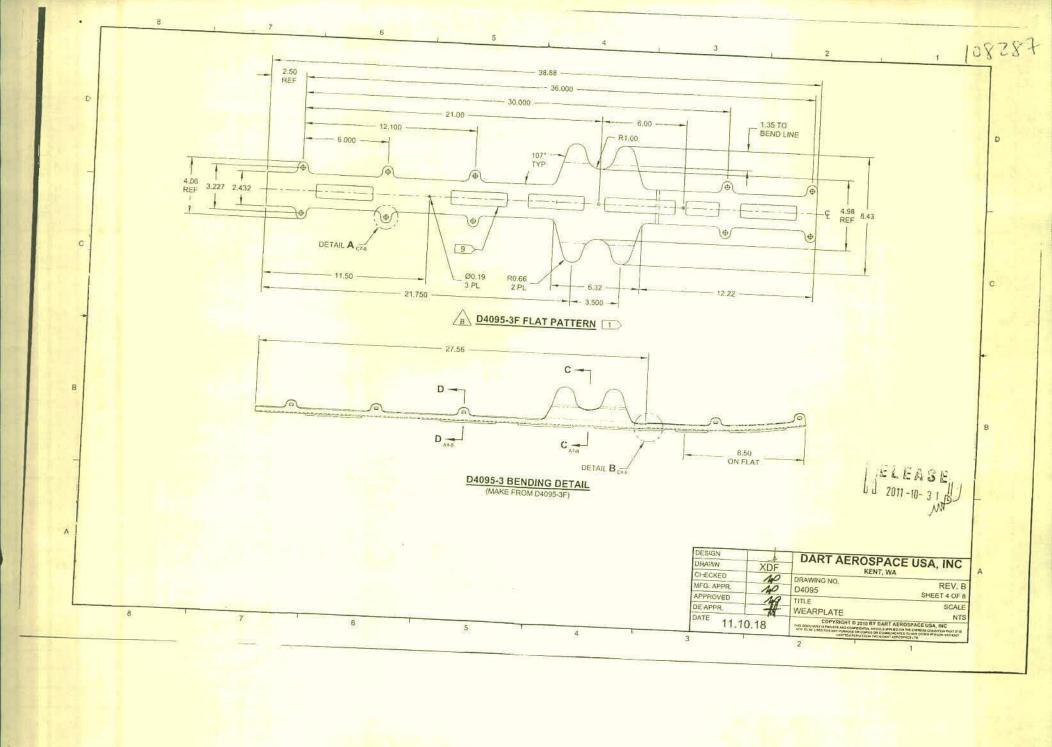
NCR: Ye	s / No				WORK ORDER NON-O	CON	IFORM	MANCE / UPDATE	Q	A Closed:	Date:	
Work Order Part No	o				DISPOSITION Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Small Fab Finishing Composite	DEPA	Proc	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance		nitial ief Eng	Action Description	100	Sign & Date	Verification	QC Inspector
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Outside Dimensions

DQA:

Date:

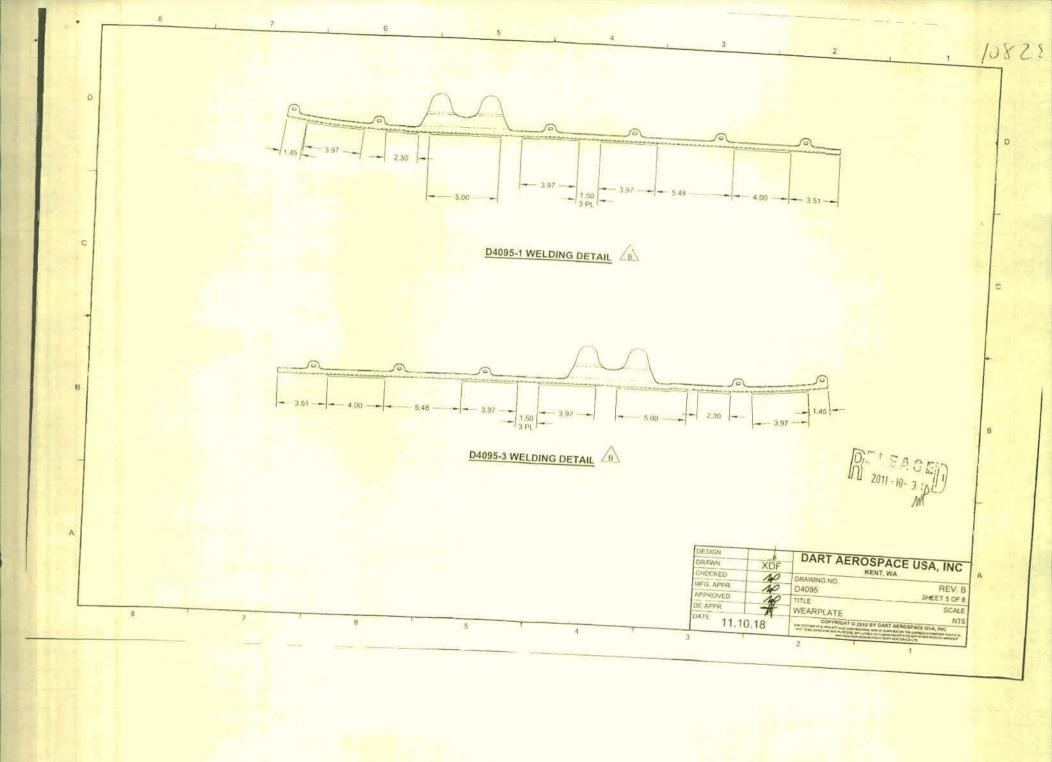
Wave/Twist in Tube



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A Closed:	Date:	

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Work Order:					DISPOSITION	AGAINST DEPARTMENT/PROC					
					Rework	We to see	Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap		Machining	Small Fab	151112	d. Eng. Coor.	Quality
mer.					Use-as-is	Th	ermoforming	Finishing	-	Other	
NCR No.					Work Order Update	1	Large Fab	Composite			
A HERITO			_		Train order opasie		8				
Root				Descri	ption of work order update	Initia	1	Action	Sign &	Control III	
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng D	escription	Date	Verification	QC Inspector
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Material									- 秋瀬		
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Other									- 海猫	E 10 10 10 10 10 10 10 10 10 10 10 10 10	
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2	Bending				Bend	Gra	in		Ovalized	THE TAX	Pressure/Forced
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The state of the s	Cracks				Broken/Damaged	Insp	ection Incomplet	e	Part Incorre	ect	Weld
	Crushed/Crimped				Burrs	Inst	ructions Incomple	ete/Unclear	Part Lost/N	lissing	Wrong Stock Pulled
- I	Cuffs				Contamination	Ma	intenance		Part Moved		
	Heat Treat				Countersink	Mis	Mislabeled		Positioned	Wrong	
	Inspection Strip in Tube			Cut Too Short	Mis	read		Power Loss	/Surge	Other	
	Ripples in Bend			Drill Holes	Offs	et		7. 17	IF YES		
	Torque Waves in Extrusion			n _	Drawing	Out	of Calibration		2575		LEAD WY LETS
Turning Sequence					Finish	Out	of Sequence		2	Later Harrison	THE TANK
Wave/Twist in Tube					Folio	Out	side Dimensions		= -4	Train to the	



DQA: Date: WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Skid-tube Water Jet Engineering Rework Crosstube Prod. Eng. Coor. Quality Machining Small Fab Part No. Scrap Rec/Store/Packaging Use-as-is Thermoforming Finishing Other Composite Supplier NCR No. Large Fab Work Order Update Description of work order update Action Sign & Initial Root or Non-conformance Chief Eng Description Verification QC Inspector Qty Date Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other Process

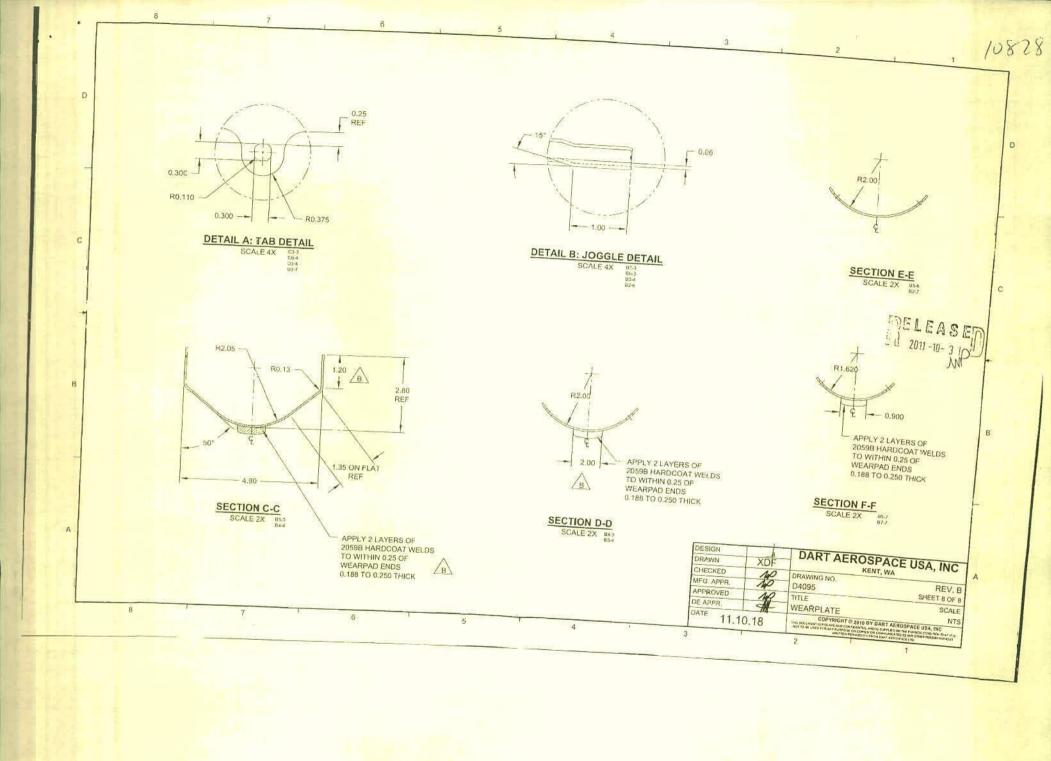
	FAULT CATEGORY									
andi	ng (Gear		General					į,	
		Bending		Bend		Grain		Ovalized		Pressure/Forced
		Centre Not Concentric to O/S		BOM/Route		Hardware	TA:	Over/Under tolerance	-	Temperature/Cure
		Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld
		Crushed/Crimped		Burrs		Instructions Incomplete/Unclear	80	Part Lost/Missing		Wrong Stock Pulled
	1	Cuffs		Contamination		Maintenance	2 7.00	Part Moved	3	
		Heat Treat		Countersink		Mislabeled		Positioned Wrong		
	71	Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge		Other
	100	Ripples in Bend		Drill Holes		Offset				
	AL.	Torque Waves in Extrusion		Drawing		Out of Calibration				
		Turning Sequence		Finish		Out of Sequence			17	

Outside Dimensions

Wave/Twist in Tube

Folio

Supplier Training Unapproved



NCR		Yes	/ No
	20	,	

Unapproved

					DUM.	Date.	MINERAL STATE OF THE STATE OF T		
NCR: Yes / No	WORK ORDER NON-C	ONFORM	MANCE / UI		QA Closed:	Date:	il in a		
Work Order:	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. NCR No.	 Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root Cause Date Step Q	ption of work order update Ini or Non-conformance Chie				Sign & Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training									

FAULT CATEGORY

Landing Gear General							18		
		Bending		Bend		Grain		Ovalized	Pressure/Forced
2		Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
		Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect	Weld
	40	Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
		Cuffs		Contamination		Maintenance		Part Moved	
		Heat Treat		Countersink		Mislabeled		Positioned Wrong	
		Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge	Other
	F	Ripples in Bend		Drill Holes		Offset	3		
		Torque Waves in Extrusion		Drawing		Out of Calibration			
10	77	Turning Sequence		Finish		Out of Sequence	1		
	W.	Wave/Twist in Tube		Folio		Outside Dimensions	-45		